

Date: Tuesday, 1/24/2006 2:50:06 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 25603		
Estimate Number	: 11347		
P.O. Number	: N/A	Part Number	: D33399
This Issue	: 1/24/2006 S.O. No. : N/A	Drawing Number	: D3339 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 25183	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/31/2006 Qty: 2 Um: Each
Checked & Approved By	: <u>SEE ABOVE USER</u>		
Comment	: Est Rev:A New Issue 05-11-10 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 7028674
 E-mail or Ship DXF file to vendor
 Laser cut flat pattern as per Dwg
 Possible supplier: Ind. Laser
 Material release note is required.

u 09-19-05 2

2.0	D33399F	Wearpad
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Comment: Qty.: 1.0000 U(s)/Unit Total : 2.0000 U(s)
 WEARPAD-FLAT

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

see attached
 Jmey

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necceray

2-Form as per Dwg D3339 using DT8326 and DT8261

SB 06/01/24 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/24/2006 2:50:06 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 25603

Part Number: D33399

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206.01.25

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Hard coat 7560 per Dwg D3339, use DT8210 & DT8810 Layout Jig

A/R 7560 Hardcoat

Batch:

M19612

CPL 06.02.13 (2)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/02/13 (2)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06 02 21 2

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06 02 22 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5427

06/2/22 (2)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/23 (2)

Job Completion



u 06.02.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/22/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Drawing name..... D3339-9A
Revision.....
Material number..... 0005, MILD STEEL 16GA, .06
Last modified date... 06-27-2005
Programmed by..... JM

Comment.....
Customer name... Dart
Description.....
Specification.....

m19186

DIM CHECK: 3 05.12.02 (Z)

REFERENCE ONLY

REFERENCE ONLY

2

3

1

4

Cutting distance = 18.2595 2.815 x 4
Rapid distance = 11.265 1.1 x 4

Товаросопроводительный документ № 0080312775
Shipping document No



CERTIFICATE OF QUALITY

ISPAT KARMET

Продавец (экспортер)
Seller (exporter)

Контракт №
Contract No

KX0939

Сопроводительный документ №

CA012

4379

ISPAT-KARMET
Kazaganda obl, g. Temirtau
Republic of Kazakhstan

Приложение
Annexure N

012

Вagon. No

67501734

Грузополучатель, страна
Consignee, country

124
Canada

P3061801001

There is no radiation contamination of metal, natural background up to 0.2 mSv/year. Content is done with NPA-1014, N. 04930 destination. Certificate about governmental verification RA.19.440, dated 04.07.2003

НТД
Standard

ASTM A1008M-02

ASTM A1008M-02

ASTM A 568M-95

.059 x 48

Показатели качества товара

Quality characteristics of goods

Номер платок Heat No	Номер партии Batch No	Химический состав (%) Chemical composition (%)											Количес- тво кошек Quantity	Группа поверх- ности Surface group	Сорт Grade
		C 100	Si 100	Mn 100	S 1000	P 1000	Cr 100	Ni 100	Cu 100	Al 100	N 1000	Al 100			
333005	2204	7.0	1.0	36.0	22.0	22.0	1.0	3.0	4.0		4.0		8		1

Номер партии Batch No	Механические свойства Mechanical characteristics								Нормы по сортам Norms by grades	План поверх- ности Flat ness	Класс шерошати- вости Surface roughness	Ка- тего- рия Сорт- ность	Вет- ровка Wind
	Предел прочности UTS N/mm²	Предел теку- щий Yield strength	Удли- нение Elonga- tion	Твер- дость Hard- ness (HRA)	Холод- ный сгиб Cold bend test	Зерни- стость Grain size	Нормы по сортам Norms by grades	Нормы по сортам Norms by grades					
9204	365.0 365.0	240.0 230.0	37.0 38.0		UD				CUT R=1,0;0,9				

Указанный в настоящем документе товар соответствует по своим свойствам и качеству требованиям, установленным в Казахстане стандартами и может быть сертифицирован на экспорт. При получении сертификата на экспорт подтверждается, что качество товара соответствует требованиям, установленным в Казахстане стандартами и может быть сертифицирован на экспорт. The goods may be exported.

Маркировка
Marking

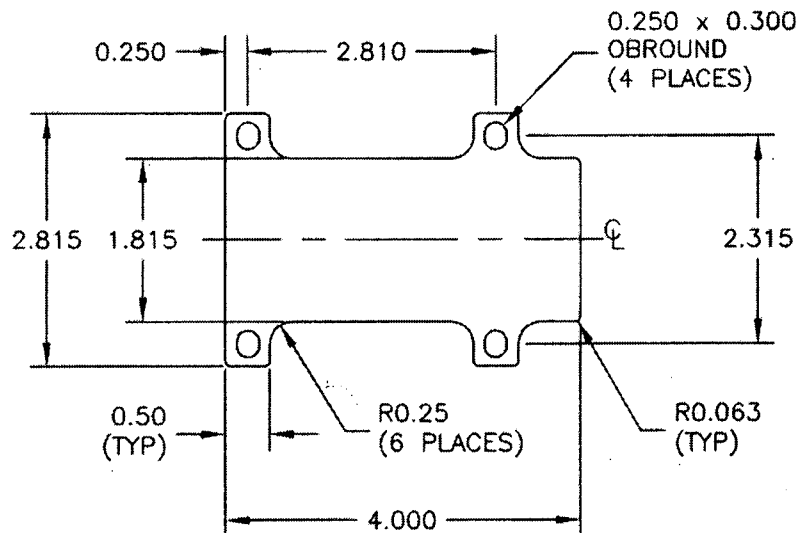
SPC Kazakhstan Ltd. Temirtau Operations
Minerals
SANDPAPER DATA

ATK
Signature
Date

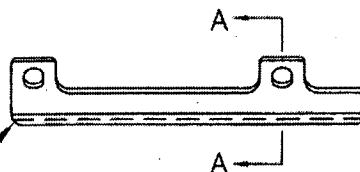
2004-12-04
11:43:11

DART

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3339	REV. B SHEET 3 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:2

**D3339-9F FLAT PATTERN****RELEASED**
05.11.27

APPLY 7560
HARDCOAT WELD BEADS
PER DT3339-9T1
AFTER FORMING
(SEE SECTION A-A)

**D3339-9 AFT WEARPAD****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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